



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW1805G01731-3G
Job Sheet 190941



Part No: RBW1805G01731-3G

Job Qty: 1 pcs **5**

DAS
21
9-89

Part Name: Mast Vibration Absorber Removal Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/20/19

Job Tracking No:

Due Date: 3/29/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG RBW1805G01731-3G REV 3 IPP REV A 18.02.16 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	3/29/19		0.00	1.00	Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	3/29/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	1 pcs	3/29/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S184244



Part: RBW1805G01731-3G

Job No: 190941

Serial No/Batch: S184244

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 05/27/19

DAS
40
9-89

MAY 30 2019

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	3/29/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

Part Op 100 - (Small Fab) 1- Assemble as per DWG RBW1805G01731-3G

Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

MAY 3 1 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
52 91590A117	External Snap Ring .375	50 10 Ea (10 ea)	100-Small Fab - 1	5118687
57 94355A227	18-8 Stainless Steel Flat-Tip Set Screws, 10-24 Thread, 1/2" Long	50 10 Ea (10 ea)	100-Small Fab - 1	19X5093312 2012 962
RBW1805G01731-3G-1	Top Plate	5 1 pcs (1 ea)	100-Small Fab - 1	5108378
RBW1805G01731-3G-3	Jack Plate	5 1 pcs (1 ea)	100-Small Fab - 1	3X5116489/2X 50 58507
RBW1805G01731-3G-5	Button	60 8 pcs (8 ea)	100-Small Fab - 1	5119337
RBW1805G01731-3G-7	Jacking Screw	80 8 pcs (8 ea)	100-Small Fab - 1	36X5118962 4X 5118942
RBW1805G01731-3G-9	Pull Screw	50 10 pcs (10 ea)	100-Small Fab - 1	5171981

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	91590A117	10	138	0
	94355A227	10	70	0
	RBW1805G01731-3G-1	1	5	0
	RBW1805G01731-3G-3	1	6	0
	RBW1805G01731-3G-5	8	64	0
	RBW1805G01731-3G-7	8	80	0
	RBW1805G01731-3G-9	10	0	0
Part Specifications				
Specifications could not be found.				

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

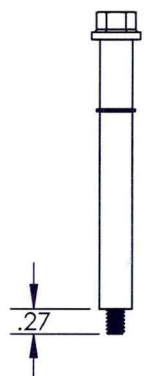
This diagram shows an exploded view of a mechanical assembly. The components are labeled with callouts as follows:

- 1**: A circular base plate with a central hole and a ring of 12 smaller holes.
- 3**: A circular cap plate with a central hole and a ring of 12 smaller holes, matching the base plate.
- 5**: 8X Small cylindrical pins or spacers.
- 7**: 8X Long cylindrical pins or spacers.
- 9**: 10X A long cylindrical pin or spacer.
- 11**: 10X A small cylindrical pin or spacer.
- 13**: 10X A small cylindrical pin or spacer.

The assembly is shown in two states: a top view where the pins (7, 9, 11, 13) are inserted into the holes of the base plate (1), and a bottom view where the pins (5, 7) are inserted into the holes of the cap plate (3). Dashed lines indicate the alignment of the components.

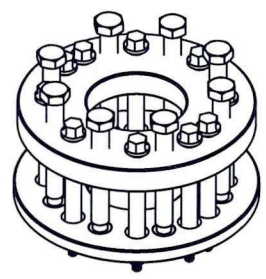
ASSY QTY	ASSY QTY	B/O	Part #	QTY.	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	TOP PLATE	S.S.		2
			-3	1	JACK PLATE	S.S.		3
			-5	8	BUTTON	4140/4142		4
			-7	8	JACKING SCREW	S.S.	3/8-24 X 3 (MCMASTER-CARR #93190A373) MODIFIED	5
			-9	10	PULL SCREW	S.S.		6
		B/O	-11	10	SET SCREW	S.S.	10-24 UNC X 1/2 (MCMASTER-CARR #94355A227)	1
		B/O	-13	10	RETAINING RING	S.S.	Ø3/8 (MCMASTER-CARR #91590A117)	1

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0288	ADDED NOTE  3 SHT 1, ADDED VIEW TO SHOW DIM OF ASSEMBLED -11 INTO -9. -1 CH'D DIM WAS Ø.355 THRU IS Ø.3564-.3555 THRU. -5 CH'D MATERIAL CALLOUT WAS 4140 IS 4140/4142. -9 CH'D DIM'S WAS 10-24 UNC ∇ .125 IS 10-24 UNC ∇ .25, WAS Ø.355 IS Ø.3550-.3544. -11 CH'D WAS #10-24 X 3/8 IS #10-24 UNC X 1/2.	9/2/2015	RJC	JAG
3	17-0143	-1 CH'D DIM'S WAS 10X Ø.3564/.3555 THRU IS 10X Ø.359/.357 THRU ALL, WAS 1.800 IS 2X 1.800, WAS 1.355 IS 2X 1.355, WAS .875 IS 2X .875, WAS .282 IS 2X .282, WAS .282 IS 2X .282, WAS .875 IS 2X .875, WAS 1.355 IS 2X 1.355, WAS 1.800 IS 2X 1.800, WAS 1.908 IS 2X 1.908, WAS 1.719 IS 2X 1.719, WAS 1.373 IS 2X 1.373, WAS .695 IS 2X .695, WAS 1.373 IS 2X 1.373, WAS .695 IS 2X .695, WAS 1.719 IS 2X 1.719, WAS 1.908 IS 2X 1.908. CH'D ENGRAVE NOTE WAS ENGRAVE P/N: "RBW1805G03351-3G" IS ENGRAVE P/N. -3 CH'D DIM'S WAS 8X Ø.192 THRU ALL $\perp$ Ø.500 ∇ .210 IS 8X Ø.192 THRU ALL $\perp$ Ø.5007/.5000 ∇ .210 (P.F.-5), WAS 1.800 IS 2X 1.800, WAS 1.355 IS 2X 1.355, WAS .875 IS 2X .875, WAS .282 IS 2X .282, WAS .282 IS 2X .282, WAS .875 IS 2X .875, WAS 1.355 IS 2X 1.355, WAS 1.800 IS 2X 1.800, WAS 1.908 IS 2X 1.908, WAS 1.719 IS 2X 1.719, WAS 1.373 IS 2X 1.373, WAS .695 IS 2X .695, WAS 1.373 IS 2X 1.373, WAS 1.719 IS 2X 1.719, WAS 1.908 IS 2X 1.908. CH'D ENGRAVE NOTE WAS ENGRAVE P/N: "RBE1805G03031-3G" IS ENGRAVE P/N. -5 CH'D DIMS WAS Ø.500 IS Ø.5016/.5012 (P.F. -.3), WAS R1.00 IS SR1.00. ADDED DIM .03 X 45°. -7 DELETED DIMS 2.75, .200. ADDED DIM'S 2.76, .213, SR 1.00. -9 CH'D DIM WAS .375 IS 3X .375/.362, WAS Ø.3550/.3544 IS .355/.353, WAS (.750) IS .75.	6/19/2017	RJC	JAG



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WITHOUT NOTICE
WORK ORDER
NO. 1909414155
1902-20

NOTE:
1. REF.
2. ALSO



NOTE:
1. REF. AUGUSTA T/N: 3G1805G01731.
2. ALSO PART OF KIT RBW1805G01431-3G,
REF. AUGUSTA T/N: 3G1805G01431.
3 USE PERMANENT LOCTITE.

			
TITLE			
MVA REMOVAL TOOL			
DWG NO.			REV
RBW1805G01731-3G			3
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± .5°	
		.X ± .1 SURFACES = 125/√	
DRAWN BY:		1. BREAK ALL SHARP EDGES	
SMITH		.015 x .45" OR .015R	
CHECKED:		2. DIMENSIONAL LIMITS APPLY	
DD 06/22/2017		AFTER PLATING	
OPPS APPR:		3. INTERPRET DIM AND TOL PER	
AA 06/26/2017		ASME Y14.5M-2009	
QA APPR:		USED ON MODEL	
JL 06/28/2017		AW139	
APPROVED:			
JAG 07/03/2017			
SCALE	1:4	DATE	4/25/2013
		SHEET 1 OF 6	